

**Claims**

1. An I.S. machine including at least one section having a blank station and a blow station comprising  
5 a section frame having a top wall,

an invert and neck ring mechanism supported on the top wall of said section frame and including  
10 a pair of opposed neck ring holder arms,

a cylinder for supporting said opposed pair of neck ring holder arms for displacement from a closed position to an open position,

15 a support structure mounted on said section frame for supporting said cylinder for rotation between a first orientation whereat said pair of neck ring holder arms are horizontally located at the blank station to a second orientation whereat said pair of neck ring holder arms are horizontally located at the blow station,

20 drive means for rotating said cylinder from said first orientation towards said second orientation to a selected orientation establishing a selected angle between said selected orientation and said second orientation, and

25 displacement means for displacing said neck ring holder arms to the open position,

30 said section frame including a downwardly extending cullet chute having a top opening defined in said top wall, said top opening extending from a location beneath said pivotally mounted cylinder towards said blow station,

5           a mold open and close mechanism supported on said section frame including an opposed pair of blow mold support mechanisms and displacement means including a motor operable to displace said opposed pair of mold support mechanisms between open and closed positions, and

10           control means comprising means for operating in a preheat blank molds mode including

15           means for maintaining the blow molds at the open position,

20           means for cyclically operating said drive means to rotate said cylinder to displace sequentially formed parisons to said selected orientation, and

25           means for operating said displacement means to displace said neck ring holder arms from the closed position to the open position when said cylinder has been rotated to locate a parison at the selected orientation.

30           2. An I.S. machine according to claim 1, further comprising deflector means for deflecting parisons released from said neck ring holder arms into said cullet chute.

35           3. An I.S. machine according to claim 2, wherein said deflector means comprises a deflector having opposed sides and a pair of arms secured to either side for hanging the deflector on the open opposed pair of blow mold support mechanisms.

4. An I.S. machine according to claim 1, further comprising deflector means for deflecting parisons released from said neck ring holder arms into said cullet chute.

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5. An I.S. machine according to claim 3, wherein  
said deflector means comprises a deflector having  
opposed sides and a pair of arms secured to either  
side for hanging the deflector on the open opposed  
pair of blow mold support mechanisms.

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6. An I.S. machine according to claim 4, wherein  
said deflector means comprises

an elongated deflector chute,  
shaft means secured to one end of said  
elongated deflector chute,  
motor means for rotating said shaft means to  
rotatively displace the elongated deflector chute  
from a retracted out of the way position to a  
vertical down position, and support means for  
supporting said shaft means above said cylinder.

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7. An I.S. machine according to claim 6, wherein  
said shaft means is the output of said motor means.

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